

Work Order ID 51405

August 21, 2009 10:17:15 AM



Page 1

Item ID: D3556-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Clamp

Start Date: 8/21/09 Start Qty: 50.00



Cust Item ID:

Required Date: 10/02/09 Req'd Qty: 50.00

Customer:

Reference:

Approvals: Process Plan: *CL*

Date: *09/08/21* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3556

Rev B

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: *10236* Cut & Form as per Dwg D3556! Material release note is required

CL 09/08/21 50

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

09/13/17 (50)

120

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

228 09/02/17

cont'd 450

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Tumble & Deburr any rough edges

B 99-81

140

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

>> 50107/21

count
(x50) f

150

0.00



Packaging

Packaging

Identify as per dwg & Stock Location: 462

Memo

0.00

109/9/22 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/09/22

MF 09-09-22

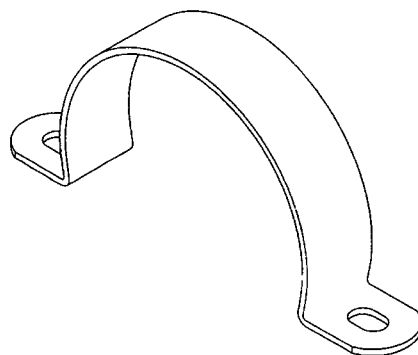
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



51405

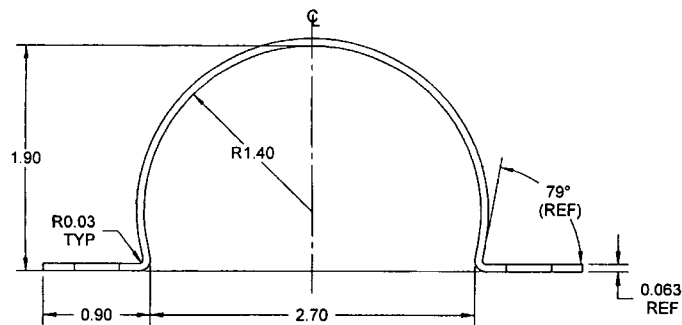
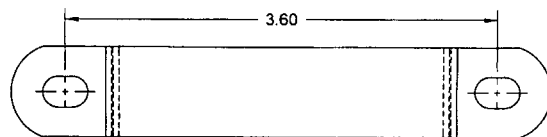
RELEASED
05-07-23

NOTES:

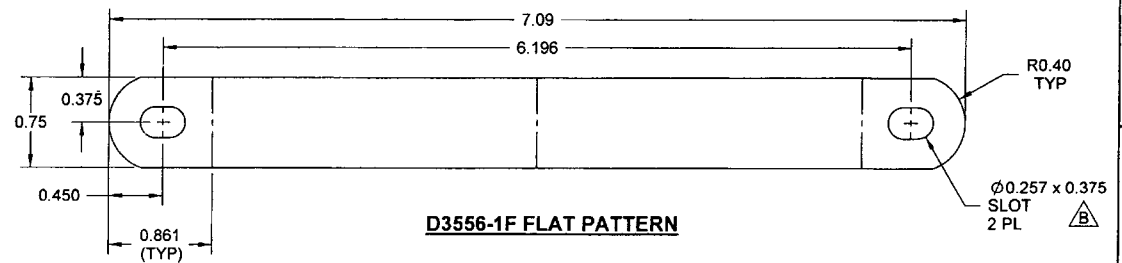
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE,
PER MIL-S-5059 (REF DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N D3556-1 USING FINE POINT PERMANENT
INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ
- 8) WEIGHT: 0.09 lbs

B	SHEET 1 NOTE 1 MATERIAL WAS MIL-S-5019. SHT 2 ZN B1 SLOT LENGTH WAS 0.357 (REF NCR 257). DRAWING TRANSFERRED TO "B" SIZE & UPDATED TO CURRENT STANDARDS.		AJS	08.07.11
A	NEW ISSUE		CB	07.02.13
REV.	DESCRIPTION		BY	DATE
DESIGN	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3556	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		CLAMP	NTS	
DATE	08.07.11		<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

C209/08/21
W10' 51405



D3556-1 CLAMP



D3556-1F FLAT PATTERN

51405

RELEASED
08.07.11

DESIGN	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	A.S.		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3556	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CLAMP	NTS
DATE	08.07.11	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO10236

Purchase Order Date 8/21/09

PO Print Date 8/28/09

Page Number 1 of 1

Order From :

VC-GFI001

GFI
180 AVENUE LABROSSE
POINTE CLAIRE, QC H9R 1A1
CA

REVISED

FAKED

Contact Name
Vendor Phone 514 630 4877
Vendor Fax 514 630 4849
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3556-1P B	CLAMP	9/10/09 Yes	50.00 Each	Purolator ground	\$5.6000	\$280.00
		Special Inst:	AS PER DWG D3556 REV. B B51405 CUT & FORM				
2	D3556-1P B	CLAMP	9/10/09 Yes	50.00 Each	Purolator ground	\$5.6000	\$280.00
		Special Inst:	AS ABOVE B51695				
						PO Total:	\$560.00

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

Change Nbr: 3

Change Date: 8/28/09

CL
W
No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



180 AVENUE LABROSSE
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

VENDU À / SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7



EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO.
2009/09/15	0424566

CODE DE CLIENT CUSTOMER CODE		N° DE CONTRAT JOB NO.	N° COMMANDE PO NO.	VIA SHIP VIA
DART GFI-0299		J0204134	PO10236	
QUANTITÉ QUANTITY	VOTRE N° DE PIÈCE YOUR PART NO.		DESCRIPTION	
100	D35561 <i>SPUR</i> MFG. JOB # <u>J0204134-01</u> QTY <u>100</u> → SO for w/o 51405 → SO for w/o 51695		CLAMP CERTIFICATE OF CONFORMANCE REQ <i>802/09/17</i>	

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

RECU PAR / RECEIVED BY

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 6 OUR JOB NO J0204134 SHIPPING MEMO 0424566

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
<u>1</u>	<u>100 PCS</u>	<u>PO10236</u>	<u>D35561</u>	<u>B</u>	<u>CLAMP</u>	<u>B</u>

MATERIAL SST 304 SUPPLIED BY TW METALS / ALLEGHENY LUDLUM MAT. REL. NO. H/N # 828977

	PROCESS	PROCESSOR	RELEASE NOTE #
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>	<u>GFI</u>	<u>CONFORMS</u>
2	<u>REF. GFI MANUFACTURING JOB NUMBER J0204134-01 (100 PCS)</u>	<u>8</u>	
3		<u>09/09/17</u>	
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 15 SEPTEMBER 2009

G.F.I. Q.C. REP. Balton Hark



DP12-001 REV 0 Bombardier Certificate of Compliance
TW Metals District Procedure

Revision 0

Revision Date 04-03-00

Superseding Initial

Page 1 of 1

CERTIFICATE OF COMPLIANCE

FRAUD AND FALSIFICATION STATEMENT

The recording of false, fictitious, or fraudulent statements or entries on this document may be punished as a felony under federal statutes including federal law Title 18 chapter 47

CERTIFICATE OF COMPLIANCE

This certificate of compliance certifies that the material supplied on the purchase order number below complies in all respects with the material description and procurement specifications

MERCURY FREE STATEMENT

We certify that mercury, radium, or alpha bearing instruments and / or equipment which might cause contamination have not been used in the manufacture, fabrication, assembly or testing of any material supplied by TW Metals Inc. Switches, glass thermometers, standard cell and other items containing the above elements may be used, but they will be located so as not to constitute a contamination hazard

CUSTOMER NAME

GFI

PURCHASE ORDER No

0075846

ITEM No

0001

SHIPPER INVOICE No

03251327

MATERIAL

304-5/5 Sheet

SPECIFICATION

Ams 2248F

MANUFACTURING MILL

ATI Allegheny Ludlum

SIZE

.0625

HEAT / LOT No

828977

PART No

TS06348X964A

QUANTITY

2EA.

TEST DEPARTMENT CLERK

Amy Davis

AUTHORITY

Joe Schab

Director of Quality Assurance

J
07/09/17

4-150-3 003

809/09/17

TW METALS
M49211888
JUN 29 2009
ACCEPTED BY

NOTICE OF SHIPMENT/
PACKING LIST

CERTIFICATE OF TEST

AL 6110-3 000

DATE, ORD NO. & DATE	DATE CODE	ACCEPTED MTL	SUPPLIER NO.	PRODUCT CODE	ROLL OTHER NUMBER	DATE SHIPPED
01014169	04/02/09 110977	VANDERGRIFF, PA.	423467	13020102060000	30-049-021	06/22/09
REPAIRS DISTRIBUTION	REPAIR ORDER	DO DATE	CONTRACT	MTL	SHIPPING LOCATION	INVOICE
1	82037-4	26		1124	TRANSPORTATION	PA 657053
PRIME	SEC.					
DSO	DSO					
584						

GRADE AND SPECIFICATIONS

CARRIER - CLAY TRANSPORT, INC.

ALLEGHENY STAINLESS STEEL TYPE 304 SHEET C R COILS ANNEALED 2B FIN 3 EDGE (UPM 304L/304/302 LCS) (AMS 2248P) (AMS 5511H) (AMS 5513H) (AMS 5516P) (ASTM-A-262-02A PRA E/SCREEN PRA A) (ASTM-A-666-03) (S-400 DTD 10/31/07) (ASTM-A-240-08A) (S-1000 DATED 1/2/08) (ASME-SA-240-07) (10/22/08 EXCEPT UPM 304L/304/302) (UNS S30403) (UNS S30200) (UNS S30400) (UPM-QRS-001) (PWA 300 REV RH) (F-14, F-17, F-22, F-23, F-MASTER) (CONTROLLED TO PWA LCS REQUIREMENTS)

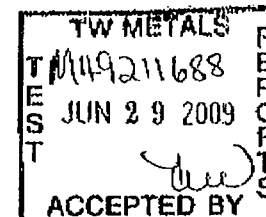
AUSTENITIC STAINLESS STEELS ARE SOLUTION ANNEALED AT 1900 DEGREES FAHRENHEIT MINIMUM (1038 C) AND RAPIDLY COOLED TO DEVELOP THE SPECIFIED PROPERTIES. EVIDENCE OF CONFORMANCE IS PROVIDED BY THE ABILITY OF THE MATERIAL TO MEET THESE SPECIFIED MECHANICAL AND CORROSION REQUIREMENTS

ALLEGHENY LUDLUM DOES NOT USE MERCURY IN THE TESTING OR PRODUCTION OF ITS PRODUCTS. TO THE BEST OF ALLEGHENY LUDLUM'S KNOWLEDGE, UNDERSTANDING, AND BELIEF, THIS MATERIAL WAS NOT CONTAMINATED BY MERCURY WHILE IT WAS BEING PRODUCED IN OUR FACILITIES.

NO WELDS/WELD REPAIRS PERFORMED.

THE NUMERIC CODES SHOWN UNDER MELT SOURCE CAN BE INTERPRETED AS FOLLOWS:

1. - MATERIAL MELTED AND ROLLED IN THE UNITED STATES AND COMPLIES WITH DFARS EDITION 1993, SECTION 252.225-7014
2. - FOREIGN MELT AND ROLLED IN THE UNITED STATES



PAGE 02 - CONTINUED ON PAGE 03

06/22/09 09:48:07

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Material Safety Data Sheets for this product have been prepared by your manufacturing organization. For an additional copy please call 724-238-6677. CAUTION: Please use the correct handling and storage procedures for this material. Safety Data Sheets are located on the back of this document.

WARRANTY: Allegheny Ludlum warrants that the material conforms to the specifications and standards set forth in this document. The material is provided as is, without any warranty, express or implied. The material is not to be used for any purpose other than that for which it was intended. The material is not to be used for any purpose other than that for which it was intended.

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